

Date: Friday, 29/08/2008 11:38:41 AM  
 User: Julie Lecocq /




## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET ASSEMBLY
Job Number	: 41672		
Estimate Number	: 11029		
P.O. Number	:	Part Number	: D2803041
This Issue	: 29/08/2008 S.O. No. :	Drawing Number	: D2803 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : PURCHASED PARTS	Drawing Revision	: B
Previous Run	: 41053	Material	:
Written By	:	Due Date	: 10/09/2008 Qty: 10 Um: Each
Checked & Approved By	: <u>JUL 08.8.29</u>		
Comment	: EST F 05.03.30 MS21043-3 was MS21042L3 KJ/JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :								
1.0	D28031	Bracket								
<div><div></div><div></div></div>										
Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) STA 84 BRACKET Pick: <table><tr><td>Qty</td><td>Part Number</td><td>Description</td><td>Batch</td></tr><tr><td>1</td><td>D2803-1</td><td>Bracket</td><td>B41738 (5x) B41079 (5x)</td></tr></table>			Qty	Part Number	Description	Batch	1	D2803-1	Bracket	B41738 (5x) B41079 (5x)
Qty	Part Number	Description	Batch							
1	D2803-1	Bracket	B41738 (5x) B41079 (5x)							
2.0	D28051	Stop								
<div><div></div><div></div></div>										
Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) STOP Pick: <table><tr><td>Qty</td><td>Part Number</td><td>Description</td><td>Batch</td></tr><tr><td>1</td><td>D2805-1</td><td>Stop</td><td>B41081</td></tr></table>			Qty	Part Number	Description	Batch	1	D2805-1	Stop	B41081
Qty	Part Number	Description	Batch							
1	D2805-1	Stop	B41081							
3.0	D2809	Bushing								
<div><div></div><div></div></div>										
Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) Bushing Pick: <table><tr><td>Qty</td><td>Part Number</td><td>Description</td><td>Batch</td></tr><tr><td>1</td><td>D2809</td><td>Bushing</td><td>B39727 (9x) B40929 (1x)</td></tr></table>			Qty	Part Number	Description	Batch	1	D2809	Bushing	B39727 (9x) B40929 (1x)
Qty	Part Number	Description	Batch							
1	D2809	Bushing	B39727 (9x) B40929 (1x)							
4.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1								
<div><div></div><div></div></div>										
Comment: SMALL & MEDIUM FAB RESOURCE 1 Press D2805-1 into arm as per Dwg D2803										

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 29/08/2008 11:38:41 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 41672

Part Number: D2803041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/10/14 (X10)

6.0

POWDER COATING

POWDER COATING



M 109152



(10X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

3:30

OVEN TEMPERATURE:

320 °C

FINISH TIME:

4:00

M-L 08/10/15

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-10-16

(X10)

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Press D2809 into arm as per Dwg D2803

CP 08/10/17 (10)

9.0

AN3C16A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Bolt

Pick:

Qty Part Number Description Batch

2 AN3C16A Bolt

M 105426 (17X)

CP 08/10/17  
M 109147 (3X)

10.0

MS210433

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Nut

Pick:

Qty Part Number Description Batch

2 MS21043-3 Nut

M 109147

CP 08/10/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 29/08/2008 11:38:41 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 41672

Part Number: D2803041

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

NAS1515H3

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s)

Washer

Pick:

Qty Part Number Description

4 NAS1515H3 Washer

A/R LPS-3

Corrosion Spray

Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2803

Batch: M107101

M109929

CP 08/10/17

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D2803.

CP 08/10/17 (10)

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/10/17 (10)

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 108

8/10/17

(10x)

36

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/21

Job Completion



MF 08-10-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector



Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

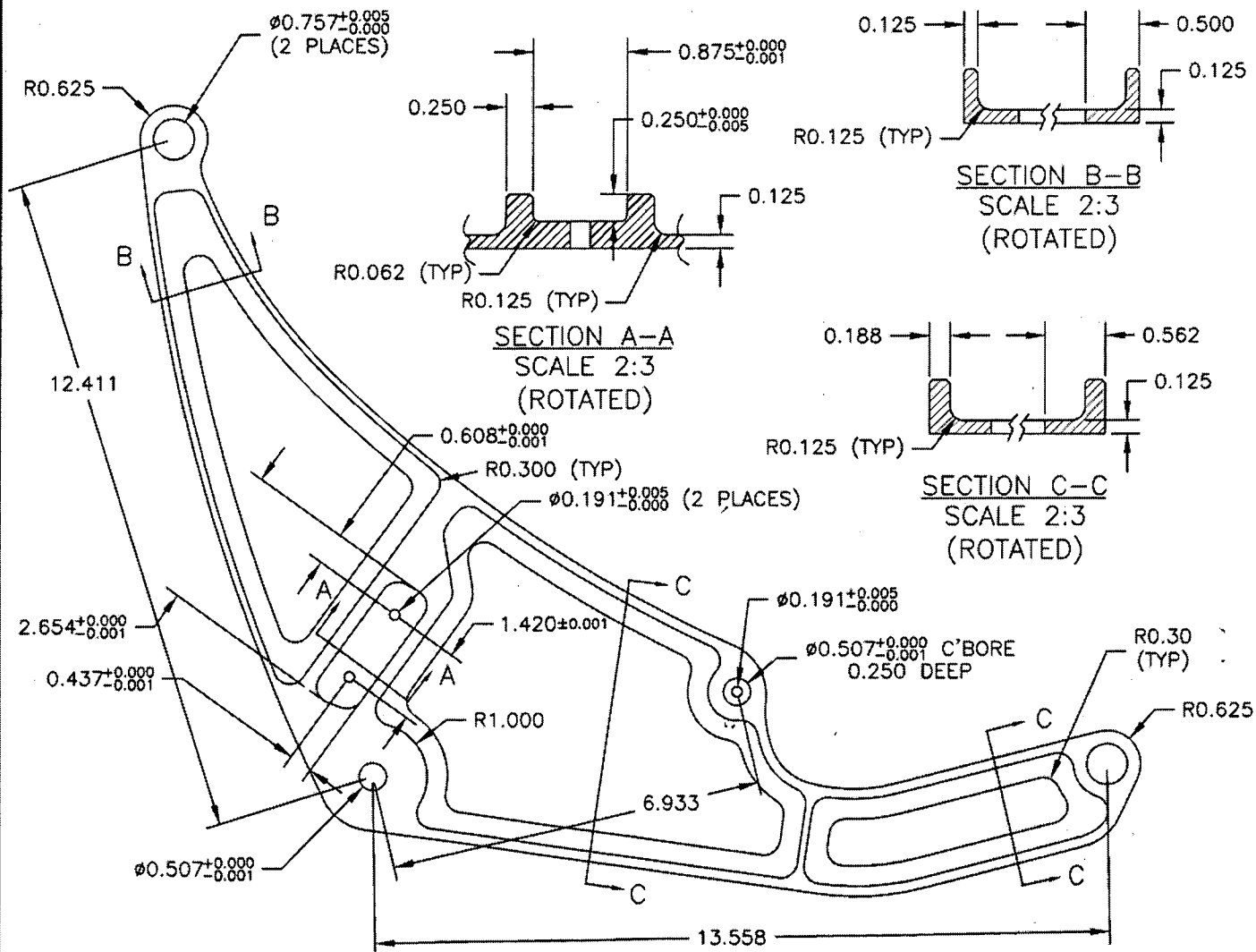

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D2803	REV. B SHEET 1 OF 2
DATE 04.11.22		TITLE STA 84 BRACKET	SCALE 1:3
A	00.11.07	NEW ISSUE	
B	04.11.22	ADD CUTOUTS & -043/-044	

RELEASED

05.03.11 **D2803-1 BRACKET (SHOWN). D2803-2 BRACKET (OPPOSITE)**

- 1) MACHINE PER DRAWING FILE "D2803.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

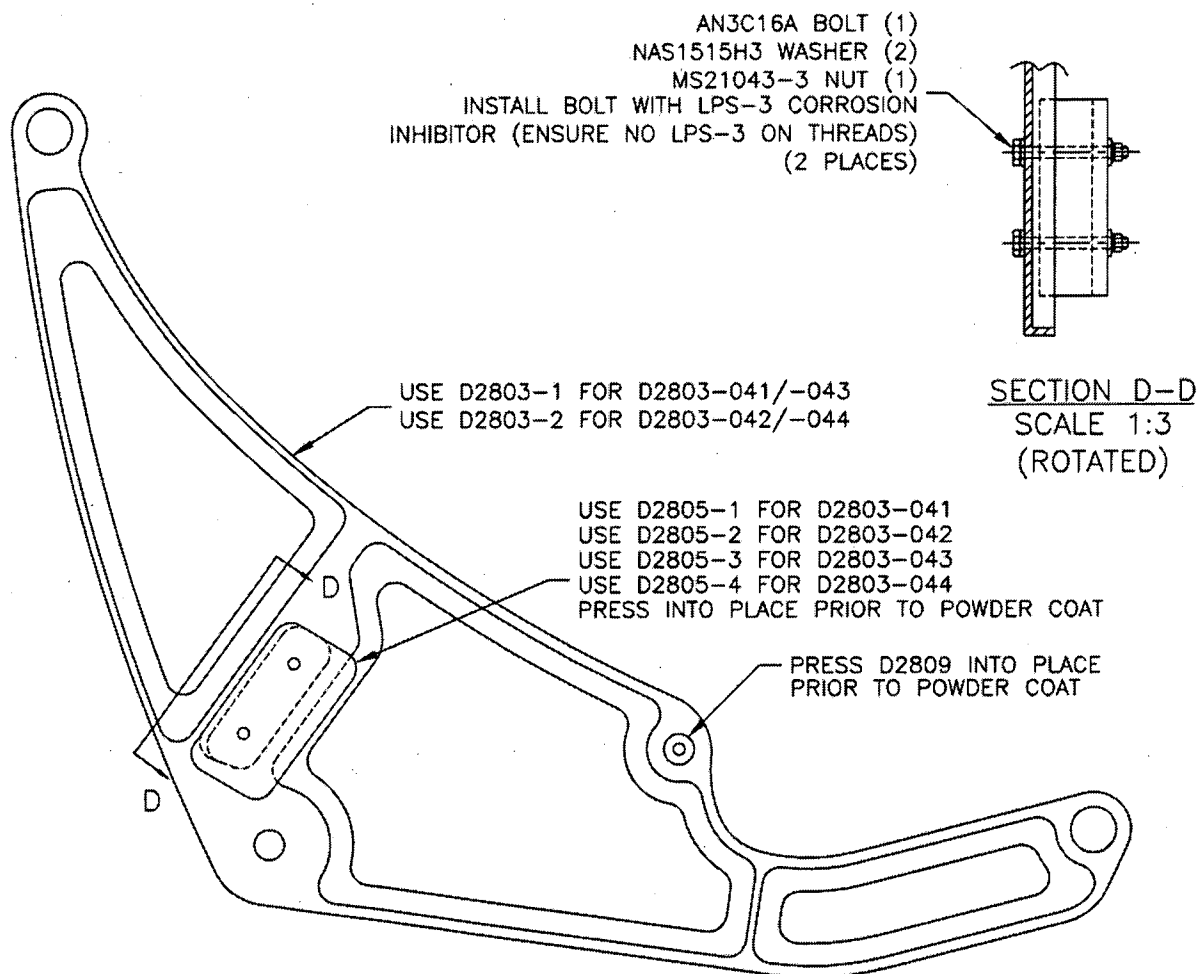
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WORK ORDER  
NO. 41672

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DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D2803	REV. B SHEET 2 OF 2
DATE 04.11.22		TITLE STA 84 BRACKET	SCALE 1:3



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**D2803-041/-043 BRACKET ASS'Y (SHOWN),**  
**D2803-042/-044 BRACKET ASS'Y (OPPOSITE)**

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)  
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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